



SPLIT

DART AEROSPACE LTD	Work Order:	24355 A
Description: Longitudinal support ass'y	Part Number:	B67-43001-45
Dwg: B67-43001-45	Qty:	17
		Page of

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	09.27	17
2	G.A	cut material per drawing <sup>B67-43001-45</sup> M6061 T6 T1.000W.063 <sup>m18/88</sup> <del>B23984</del>	K	05-09-20	17
3		deburr tube inside & outside	K	05-09-20	17
4		drill holes as per drawing	W	05/09/28	17
5	QC	inspect	B	0509.28	17
6		Inspect Level 21	LD	05/11/18	17
		See B23984 for complete w/b			

See lost these

Rev	Date	Change	Revised By	Approved





SPLIT A

DART AEROSPACE LTD		Work Order:	23984
Description: LONGITUDINAL INBOARD ASSY		Part Number:	B67-43001-45
Dwg: B67-43001	P.13	Qty:	5
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler			
2	GA ✓	CUT B67-43001-757 (DWG SH.31) AS PER DWG REV'D MAT. 6061-T6 $\phi 1.000" \times 0.065"$ WALL THICK 41.40" LONG B: M18188	FF	05.09.26	5
3	GA	DRILL $\phi 0.250"$ HOLES (2) AND $\phi 0.040$ PILOT HOLE (1) AS PER DWG B67-43001-757 (SH.31)	FF	05/09/27	5
4	GA	DEBUR	FF	05/09/27	5
5	GA ✓	PICK: ✓ B67-43001-92 B: B23985 ✓ 240-107 PIW B: M18070	FF	05.09.27	5
6	GA	INSTALL B67-43001-92 ON B67-43001-757 THEN DRILL $\phi 0.30$ ( $\phi 0.118$ ) HOLE THRU BOTH PARTS AS PER DWG B67-43001-45 REV'D.	FF	05.09.27	5
7	QC5	INSPECT DIMENSIONS + ASSEMBLY		05-09-28	5
8	FP	CHEM CONVERSION COAT PER DART OSI 4.1.2.1	M	05-09-28	5
9	FP	PAWDER COAT GREEN DUPLEX PER DART OSI 4.3.5.8. MASK HOLES.	M	05-09-28	5
10	QC3	INSPECT PAWDER COAT		05-09-29	5
11	GA ✓	PICK: ✓ D3447-1 (1) B: <u>23989</u> ✓ D3447-5 (1) B: <u>M17406</u> ✓ A4-13A DART (1) B: <u>M18057</u> ✓ A51149 F3432 P WAXER (2) B: <u>M15924</u> ✓ A5216424 OUT (1)		05-09-29	5
12	GA	ASSEMBLE A) PER DWG.		05-09-29	5
13	QC5	INSPECT ASSEMBLY		05-09-29	5
14	AC	COST/POW			
15	DC	CLOSE UP LEVEL 21			

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